#### Work Order ID 56264

Wednesday, February 17, 2010 11:05:05 AM



Page 1

Item ID:

D206-642-341

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Required Date: 3/4/2010

Replacement Skidtube

**Start Date:** 

2/18/2010

Start Qty: 1.00

Rea'd Otv: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

QC:

Date:

Date:

**Tooling:** 

Date:

Date:

Start Run

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** 

SPC(Y/N):

Draw Number Draw Rev.

Plan

Code

Accept Oty

Reject Qty

Reject

Insp. Number Stamp

**Draw Nbr** 

**Revision Nbr** 

100

DOCUMENT CONTROL

Memo

0.00

0.00

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341

110

Skidtubes

Skidtubes Skidtubes

flush to cap on top surface only. 15-Cut af

120

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

M10/2/23

Dart Aerospac	e Ltd
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W/O:			W	ORK ORDER CHANG	GES				*	
DATE	STEP	PR	OCEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			-74-10-							
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	t: Yes No DQA: Date:				
	Re	solution:	Disposition	n:	QA: N/C (	Closed:		Date: _	*****	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			,	
DATE	STEP	Description of NC		ction B	Verif	cation	Approval	Approval		
	STEP Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat			Chief Eng	QC Inspector	
		7.00								
	1		1		I	1		1	ľ	



1-Deburr Fwd edge of tube
2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650
3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R Aluminum Rod <u>M/12507</u>   M/13207 DE 10/02/22
4-Grind weld flush to cap on top surface only.
5-Cut aft end to lenght as per dwg D2650 $\mu$ (2/2/22
6-Drill pilot holes using drill Jig DT8168A (A,& B ) and DT8025. Open to Ø0.312"
6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"  7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".  8-Open Aft Cap Hole using #6 Drill Bit  9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail
8-Open Aft Cap Hole using #6 Drill Bit
9-Open holes for Tow Ring to $\emptyset$ 0.625" as per Dwg D2650, D2650-5 Drilling Detail $/$
10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650
11-Deburr and Blow out all chips form inside the tube $u(9/2/2)$
Seq 130  1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)
2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.
4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting
Start Date: 1010 Time: 10:30 an
Finish Date: iolul24 Time: 81200m
A/R Sikaflex-291 M 112429
Sikaflex expiry date: 1012/39 Deburr Fwd edge of tube
2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650
3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R Aluminum Rod

Page 2

Item ID:

Wednesday, February 17, 2010 11:05:05 AM

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

D206-642-341

**Cust Item ID:** 

**Customer:** 

2/18/2010 **Start Date:** 

Required Date: 3/4/2010

QC:

Start Oty: 1.00 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

\_\_\_\_ Date:

Date:

**Tooling:** 

SPC (Y/N):

Run

Stop

Start

Sequence ID/

Operation **Description** 

Set Up/ **Run Hours**  Draw Number

**Draw** Rev.

Date:

Date:

Plan Accept **Qty** Code

Reject Reject **Qty** 

Insp. Number Stamp

Work Center ID 130

Skidtubes

Skidtubes

Memo

Memo

0.00

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)[2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid): 13-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. \$\square\$4-Bond D26

4172123

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

E 10/12/24

150

Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. □A/RAluminum Rod 112507 □2-Grind welds flush as per Dwg D2650. Masking Tape access to

BE 10/01/25



									-	
W/O:			W	ORK ORDER CHANG	ES	. , .				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			***							
Part No					NCR: Yes No DQA: Date:					
	Re	esolution:	Dispositio	n:	_ QA: N/C CI	osed:		Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval	
DAIL	SILF	Section A	initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector	
			·							
					3					
		.,								

(	Seg. 150)
	1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650.
ļ	Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
,	A/R Aluminum Rod $M112507$ BE 10/02/25
;	2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube $B_{color)}$
:	3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr 8 15 10/02/25
Mo.cx 35t	1- Instell nut plate aspending BE 10/02/25
(	Sea 190
1	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.
	(6 220)
,	(Seg 220) 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing
	wearpad/wearplate.
i	A/R Sikaflex-291
;	Sikaflex expiry date:
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive
;	3-Install MS27039-4-06 Screw as per DEO 9153
•	4-Inspect for foreign object per QSI 024
!	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
	A/R Sikaflex-291
:	Sikaflex expiry date:
(	6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch:

180

Quality Control

Page 3

Wednesday, February 17, 2010 11:05:05 AM Item ID: D206-642-341 Accept Setup Start **Revision ID:** Stop Item Name: Replacement Skidtube **Start Date:** 2/18/2010 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 3/4/2010 **Customer:** Reference: Run Start Process Plan: **Approvals:** Date: Tooling: Date: Stop QC: Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Accept Set Up/ Draw Draw Reject Reject Plan Work Center ID Description Number Qty Number Stamp **Run Hours** Rev. Code Oty 160 0.00 HandFinishing HandFinish 0.00 BE 10/02/25 Memo Hand Finishing Install D2680-041 Nut Plate as per Dwg D2650 170 QC10- Inspect visual per QSI004- ground welds 0.00 0.00 Memo Quality Control

0.00

QC5- Inspect part completeness to step on W/O

Memo

W/O:		WORK ORDER CHANGES													
DATE	STEP	PRO	PROCEDURE CHANGE By												
			WWh												
		PAR #:	Fault Cat	tegory:	_ NCR: Yes I	NCR: Yes No DQA: Date:									
	R	esolution:	Dispositi	ion:	QA: N/C Clo	sed:	Date: _								
NCR:		·	WORK ORI	DER NON-CONFORMA	ANCE (NCR)										
DATE	STED	Description of NC		Corrective Action Section		Verification	Approval	Approvai							
DAIL	SILF	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector							
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START\_TIME:

Powder Coating

LIOVEN TEMPERATURE:

QC3- Inspect Part Finish

0.00

BR 10-03-23 Q

210 QC

Quality Control

Memo

0.00

W/O:			WC	RK ORDER CHAN	IGES	· · · · · · · · · · · · · · · · · · ·				i/
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		1 24 - 1								
Part No:		PAR #:	Fault Cate	gory:	Yes N	No DQA: Date:				
		solution:								*
NCR:			WORK ORDI	ER NON-CONFORM	MANCE	(NCR)				
DATE	OTED	Description of NC		Corrective Action Se					Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Verific Section		Chief Eng	QC Inspector
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Page 5

Wednesday, February 17, 2010 11:05:05 AM Item ID: D206-642-341 **Revision ID:** Item Name: Replacement Skidtube **Start Date:** 2/18/2010 Start Oty: 1.00 Required Date: 3/4/2010 Req'd Qty: 1.00 Reference: Process Plan: Approvals:

Accept

Setup Start

Stop

**Cust Item ID: Customer:** 

Date:\_\_\_\_\_

Date:

Tooling:

Date:

Date:

Start

Stop

Sequence ID/ **Work Center ID** 

QC:

Operation **Description** 

Set Up/ **Run Hours** 

SPC (Y/N):

Draw Number Draw Rev.

Plan Accept Code **Qty** 

Reject **Qty** 

Run

Reject Insp. Number Stamp

220

HandFinish

HandFinishing

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. [] A/RSikaflex-

291/13 445 USikaflex expiry date: 10/08 U2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly

BR 10-3-23 @

230

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

240

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PR	PROCEDURE CHANGE						Approval QC Inspector
								Prod Mgr	
		7.5							
Part No	:	PAR #:	Fault Cate	Date:					
		solution:							
NCR:			WORK ORD	ER NON-CONFORM	MANCE (NO	R)			
DATE	STED	Description of NC	Description of NC Corrective Action			Verifi	Verification Approva		Approval
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	Sect	tion C	Chief Eng	QC Inspector
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#### Work Order ID 56264

\*Wednesday, February 17, 2010 11:05:05 AM



Page 6

Item ID:

D206-642-341

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** Required Date: 3/4/2010

2/18/2010

Start Qty: 1.00

Operation

Packaging

Description

**Req'd Qty:** 1.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

**Process Plan:** 

Date:

Tooling:

Date:

Draw

Rev.

Start

Stop

Run

Stop

QC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Sequence ID/ **Work Center ID** 

250

Packaging

Packaging

Memo

Memo

Identify and pack for shipping as per PPP D206-642/ S6260

0.00

0.00

260

QC21- Final Inspection - Work Order Release

0.00

Quality Control

0.00

10/04/1294 MF 10-49

Dart Aerosp	ace Ltd
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W/O:		WORK ORDER CHANGES													
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector					
									·						
			***************************************												
		PAR #:													
	Res	olution:	Dispositio	n:	QA: N	C Clo	sed:		Date: _						
NCR:			WORK ORD	ER NON-CONFO	RMANCE (I	VCR)		-							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descript	scription Sign &			ation	Approval Chief Eng	Approval QC Inspector					
			Chief Eng	Chief Eng		Date									
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Picklist Print												Page
Wednesday, Februa	ary 17, 2010 11:05:	05 AM										ر ا
Work Order ID: 50	6264											/
Parent Item: D	206-642-341											
Parent Item Name:	Replacement Skidtu	be		// /= /= // // // // // // // // // // /		****** #189(		St	art Date: 2/18/	2010	Required Date:	3/4/2010
Comments:	IPP Rev: H 305.10. IPP Rev:I 08-09-2		429-1 per CHG004□KJ/CP/JLM or dwg DD verified by:				S	Start Qty: 1.00		Required Qty: 1.00		
Component Item ID/ Item Name ALS4-1032-130	Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure Each	<b>Qty on Hand</b> 1,908.000	Remaining Qty To Pick 54.0000	Qty Issued	Date Issued	Status
AN960C10L	HE NAM BANA I NAM	Purchased	No	Wareho Loc Main W ST	ation		Otv 1908 1908 Each	Loc Code 388.0000	54.0000	54.	BL 16-	3-23.
	NUAS 114	90033 <i>6</i>	₽ <b>2</b> .	Wareho Loc OFFSHO FG	ation	Loc (	<b>Oty</b> 100 100	Loc Code	_	54 - ,	bl 10-3-	<b>3</b> 3.

warehouse	Loc Oty	<u>Loc Code</u>	
<b>Location</b>			
OFFSHORE	1		
FG 11369 (	100		
103585	100		
Main Warehouse			
ST	288		
112116	128		
112612	160		

	. A	<b>\er</b>	0	sp	ac	ce	Lt	d
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W/O:		WORK ORDER CHANGES								
DATE	ATE STEP PROCEDURE CHANGE			ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	):	PAR #:	Fault Cate	egory:	NCR:	Yes N	do DO4		Date:	
			Disposition:							
NCR:				DER NON-CONFORM						
DATE STEP Description of NC			Corrective Action Section			Verification		Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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NOTE ~										

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:



Start Date: 2/18/2010

Required Date: 3/4/2010

Start Oty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

AN960JD10L

Replacement Mfg/ Item ID

Purch Purchased

Bin Primary Location Item No

Last Location Route Seq ID

Unit of Measure Hand Each

Oty on

Remaining **Qty To Pick** 3,457.000 2.0000

Otv Issued Date Issued

Status



Washer

Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		
ST	3457	
101291	16	
105793 /	49	
110985	3392	

AN960JD416

Purchased

NAS 149 DO 463 J M13706.

Each

1.0000

2 pl 10-3-23. 1 bl 10-3-23.

Washer

CCR264SS3-3

Purchased

No

521.0000 2.0000

0.0000



Cherry Rivet

Warehouse	Loc Qty	Loc Code	
Location	<u> </u>	<u> Lot cout</u>	
Main Warehouse			
ST	29		
111548	20		
111827	1		
112314	2		
113539	6		
Main Warehouse			
ST311	492		
			-2

492

BE 10/02/25

113973

	•								
W/O:			WO	RK ORDER CHANG	ES				
DATE STEP PROCEDURE CHANGE By				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	<u> </u>	PAR #:	Fault Cated	lory:	NCP: You	No DO	۸.	Data	
		olution:							
NCR:				R NON-CONFORMA					
DATE	STEP	Description of NC		Corrective Action Section	T-04	Verific	ation	Approval	Approval
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
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#### **Picklist Print**

Page 3

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev: HO05.10.11GAdded D3429-1 per CHG004GKJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Manufactured

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

CR3212-4-03

Replacement Mfg/ Item ID Purch

Purchased

Primary Bin Item Location No

No

Last Location Route Seq ID Unit of Measure Each

Qty on Hand 242.0000 2.0000

Otv Remaining **Qty To Pick** Issued Date Issued

Status

Cherry Rivet

Warehouse Location

Main Warehouse

ST

111359 112314

Loc Qty

Loc Code

Each

242 84 158

> 10 10

10.0000 1.0000

BE 10-02-25

D2620



Skidtube, 206 Skidtube

Warehouse

Location

Main Warehouse ST

Loc Qty

Loc Code

<del>-</del>										,
W/O:		9/2	W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Dațe	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
					* ;					
Part No	:	PAR #:	Fault Cate	egory:	_ NCI	R: Yes	No <b>DQ</b>	A:	_ Date: _	
				ition: QA: N/C Clos						
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR	)			.,,,,,,
DATE	STEP	Description of NC			tion B		Verific	ation	n Approval App	
DAIL	SILF	Section A	Initial Chief Eng			Sign & Date	Section C		Chief Eng	Approval QC Inspector

#### **Picklist Print**

Page 4

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

Parent Item:

Comments:

D206-642-341



Parent Item Name:

Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D2646

Replacement Mfg/ Item ID Purch Manufactured

Manufactured

Bin Primary Item Location No

Last Location Route Sea ID Unit of Qty on Measure Hand 55.0000 Each

Remaining Qty To Pick 1.0000

Qty Issued Date Issued

Status

Aft Cap

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
FP6	29		
52663 <b>V</b>	29		1 1/10
Main Warehouse			,
fp7	13		
52663 `	13		
Main Warehouse			
ST	13		<del></del>
46327	4		
48109	9		
	Each	90.0000 1.0000	0

D2647

Cap

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		
ST	90	

55352

W/O:			WC	ORK ORDER CHANG	iES		-	<u> </u>		
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		400								
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _		
	•				QA: N/C Clos					
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)			-	
DATE	STEP	Description of NC			ion B	Verific	Verification Approval A		Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	ion Sign & Date		on C	Chief Eng	QC Inspector	
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#### **Picklist Print**

Page 5

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev: H005.10.110 Added D3429-1 per CHG0040KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

**Start Date: 2/18/2010** 

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D2649

Replacement Mfg/ Item ID

Purch Manufactured

Manufactured

No

Bin Primary Item Location No

Last Location Route Seq ID

Unit of Oty on Measure Hand

Each

Remaining Qty To Pick 245.0000 19.0000

Qty Issued Date Issued

Status

A TARTIKA 1848 MATA BAKA ATATA (UKI 1884

I IEBRII (BIE HEIT I	
Cross Bolt Sp	acer

Warehouse	Loc Oty	Loc Code		
Location				
Main Warehouse				
LG	218			
51529	3			, ,
55000	215		19	BE 10/02/25
Main Warehouse				- 17 71.5
ST	27			
36013	5			
47112	18			
48271	4			
	Each	450.0000 14.00	000	

D2651-1

Plug

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		
fpa	295	
53349	295	
Main Warehouse		
ST /.	155	
51530	155	

14 BR 10-3-23.

W/O:			W	ORK ORDER CHANG	SES		<del>-</del> .		,••,••
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
		esolution:							
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	R)	1877		· · · · · ·
DATE	STEP	Description of NC	Initial	Corrective Action Section Description	tion B		cation	Approval	Approval
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Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

D206-642-341



Replacement Skidtube

Comments:

Parent Item:

IPP Rev: HE05.10.11@Added D3429-1 per CHG004@KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Manufactured

No



Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name D2651-3

Replacement Mfg/ Item ID

Purch Manufactured Bin Primary Item Location No

Last Location Route Seq ID

Measure Hand

Unit of

Each

Oty on Remaining Qty To Pick Issued 639.0000 14.0000

Qty

Date Issued

Status

O-Ring

-		Warehouse	Loc Qty	Loc Code
		Location		
		Main Warehouse		
		ST	639	
		43849	3	
		43849 46114	636	
Manufactured	No		Each	4.0000

-14, bk 10-3-23. 1.0000

D2654-5

Web

Warehouse	Loc Qty	Loc Code	•
<b>Location</b>			
Main Warehouse			
ST	4		
46638	4		
	Each	54.0000	1.0000

h10/2/23

D2680-041



Nut Plate

Warehouse Location	Loc Oty	Loc Code		
Main Warehouse				
ST021	54			
33061	1			1 /20
55366	53		/	BE 18/02/25

	•										
W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHA	NGE	By Date Qty			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		-									
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	es No	DQ/	<b>A:</b>	Date:		
			Dispositio	1:	_ QA: N/C	DA: N/C Closed: Date:					
NCR:		,	WORK ORDI	ER NON-CONFORMA	ANCE (N	CR)					
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description				Verific	ation	Approval	Approval	
		Section A	Chief Eng	Action Description Chief Eng		n & ite	Section	on C	Chief Eng	QC inspector	
										-	

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

Parent Item Name:

D206-642-341

Comments:

Parent Item:

Replacement Skidtube

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

**Start Date: 2/18/2010** 

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Item ID D3535-11

Replacement Mfg/

Purch Manufactured

Manufactured

Manufactured

Primary Item Location No

Last Location

Route Seq ID

Unit of Measure Each

Qty on Hand 8.0000

Oty Remaining Qty To Pick 1.0000

Issued

Date Status

Issued

Wearshoe

No

No

Main Warehouse

Loc Oty

Loc Code

8 Each

10.0000

Loc Code

1.0000

D3535-23

Wearshoe

Warehouse Location

ST

Warehouse

ST

Location

Main Warehouse

534671

Loc Qty

10 10 Each

bl 10-3-23. 17.0000 1.0000

D3535-35

Wearshoe

Warehouse Location Main Warehouse

ST

51608

Loc Qty

17

17

Loc Code

-1-1/2/10-3-8.

W/O:			W	ORK ORDER CHANG	ES	£ 1.65. 1 to				
DATE	STEP	PRO	OCEDURE CHA	NGE	I	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									,	
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo <b>DQ</b>	<b>4</b> :	_ Date: _	
	Re	esolution:	Dispositio	n:	QA: N	I/C Clo	sed:		_ Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (	NCR)				
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
				•						
		•								

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Manufactured

No

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Item ID D3536-11

Replacement Mfg/ Purch

Bin Item Manufactured No

Primary Last Location Location Route Seq ID

Unit of Measure Each

Qty on Hand 16.0000 1.0000

16.0000

1.0000

Remaining Qty Qty To Pick Issued Date Issued

Status

Gasket

Warehouse Loc Qty Loc Code Location Main Warehouse ST 16

12 46715 Each 1 Bl 10-3-33.

D3536-23

Gasket

Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		
FP	3	
51609	3	
Main Warehouse		
ST	13	
30754 53468	1	
53468	12	

1 pl 10-3-23.

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W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No	DQA	\;	_ Date: _	
Resolution:			Disposition	n:	_ QA: N/C	Close	ed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NO	CR)				
DATE	STEP	Description of NC	Corrective Action Section			Verific		cation Approval		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		Section	on C	Chief Eng	QC Inspector
										:

#### **Picklist Print**

Page 9

· Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

D206-642-341

Parent Item Name:

Replacement Skidtube

**Comments:** 

Parent Item:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

**Start Date: 2/18/2010** 

Required Date: 3/4/2010

Start Oty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name D3536-35

Replacement Mfg/ Item ID

Purch Manufactured

Manufactured

Bin Primary Location Item No

No

Last Location Route Seq ID Unit of Measure Each

Oty on Hand 19.0000

Remaining Oty **Oty To Pick** Issued 1.0000

Status

Date Issued

Gasket

Warehouse Location

Main Warehouse

ST

51628

Loc Qty

Loc Code

19 19

Each

153.0000 6.0000

-BL 10-3-23.

D3537-1

Wearpad

Warehouse Location Main Warehouse FP

48288 55465 Main Warehouse FP17

> 51678 51679

Loc Qty

74 2 72

79 78 Loc Code

\_6 bl 10-3.23.

Dart Aerospace Ltd	Dart	<b>Aeros</b>	pace	Ltd
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W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	:	_ Date: _	
		solution:							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR	)	•		10
DATE	STEP	Description of NC			ion B	- Verifica	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio		Chief Eng	QC Inspector
	1		1				1		•

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

No

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name D3537-3

Replacement Mfg/ Item ID

Purch Manufactured

Purchased

Bin Primary Item Location No

Last Location Route Seq ID Unit of Measure Each

Otv on Hand 32.0000

Remaining Qty Oty To Pick Issued 1.0000

Date Issued

Status

Wearpad

Warehouse Loc Qty Loc Code Location Main Warehouse ST 32 33881 4 35697 28

Each

2,169.000 54.0000

Screw

MS27039-1-08

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		
ST	2169	
110467 110552	3	
110552	166	
110835	2000	

54 BK 10-3-28.

JBR 10-3-23.

## **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval** DATE STEP **Approval PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_ Date: \_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D.4.T.F.	0750	Description of NC		Corrective Action Section B			Ammuousal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

D206-642-341

Parent Item Name:

Replacement Skidtube

**Comments:** 

Parent Item:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

**Start Date: 2/18/2010** 

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch Bin Primary Item Location Last Location Route Seq ID Unit of Measure

Oty on Hand

Remaining Qty **Qty To Pick** Issued Date Issued

Status

MS27039-1-08

Purchased

No

Each

2,169.000 2.0000

Screw

Loc Oty	Loc Code		
2169			
3			
166			
2000			
	2169 3 166		

MS27039-4-06

Purchased

No

Each

49.0000 1.0000

Loc Code



Screw

Warehouse Loc Qty Location Main Warehouse ST 49 109061 49

1 pl 10-3200

2 bl 10 3-23.

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector

Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_ Date: \_\_\_

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NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)	77,01		F-12
DATE ST		Description of NC	Corrective Action Section B		3	Verification	A	A
	DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

QTY QTY PART NUMBER DESCRIPTION D2650-1 SKIDTUBE ASSEMBLY X D2650-3 SKIDTUBE ASSEMBLY Х x D2650-5 SKIDTUBE ASSEMBLY X D2650-7 SKIDTUBE ASSEMBLY EXTRUSION D2600-1-160 D2654-1 WEB D2654-3 WEB 1 WEB D2654-5 D2654-7 WEB AFT CAP D2646 1 1 1 D2647 CAP CROSS BOLT SPACER 17 19 23 18 D2649 16 18 14 22 D2651-1 PLUG 18 22 16 14 D2651-3 O-RING NUT PLATE D2680-041 2 2 D3286-1 DOUBLER D3286-3 2 2 STUD INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130 42 44 54 60 ALS7-1032-130) WASHER 2 2 2 2 AN960JD10L CCR264SS3-3 RIVET 2 2 2 2 RIVET 2 2 2 2 CR3212-4-03 SCREW 2 2 2 2 MS27039-1-08 MS27039-4-06 SCREW AN960JD416 WASHER 1 RIVET 52 52 CR3212-4-04

D

В

NOTES:

/F

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С

В

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND, IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5
- TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

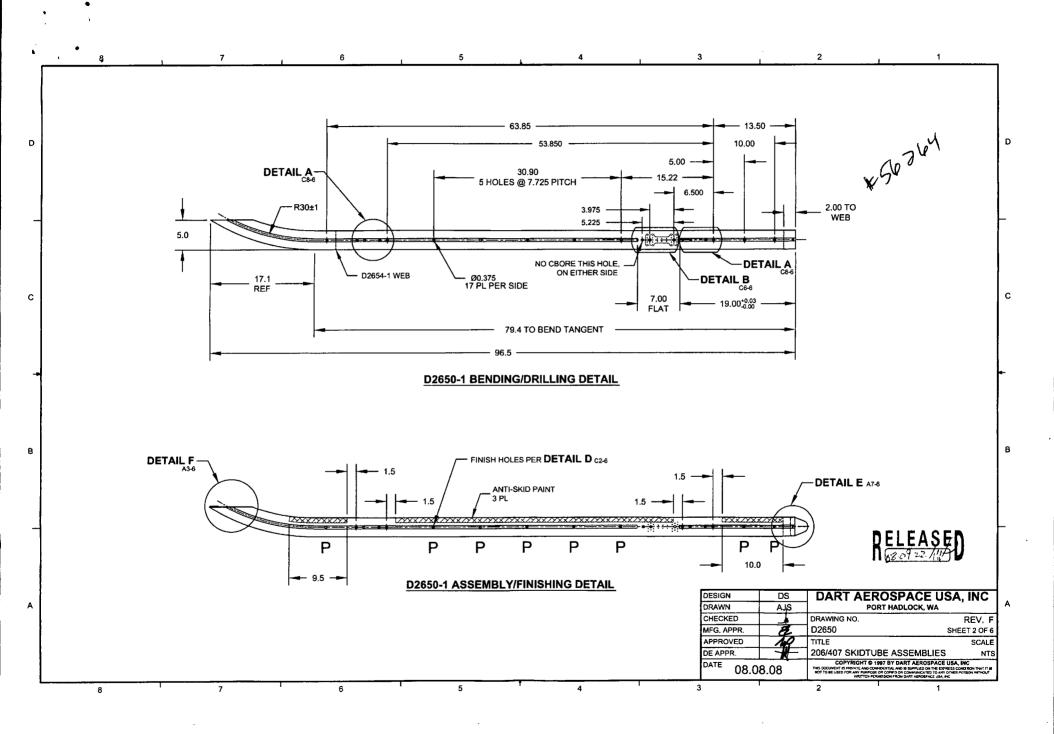
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 CTY UPDATED. SHT 6 SECT C-0 GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NOR 239).	AJS	80.80
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	Ĉ	04.05.17
С	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
В	AS MANUFACTURED CHANGES	DS	97.06.26
Α	NEW ISSUE	os	97.03.25
REV.	DESCRIPTION	BY	DATE

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA				
DRAWN	AdS					
CHECKED		DRAWING NO.	REV. F			
MFG. APPR.	2	D2650 s	HEET 1 OF 6			
APPROVED	10	TITLE	SCALE			
DE APPR.	-1	206/407 SKIDTUBE ASSEMBLIES	NTS			
DATE 08.0	8.08	COPYRIGHT © 1997 BY DART AEROSPACE UP THIS DOCUMENT IS PRIVATE AND COMPOSITION, AND IS SUPPLIED ON THE EXPRESS NOT TO BE USED FOR ANY PURPOSE OF COMPANIES TO ANY OF ANY PURPOSE OF COMPANIES AND ANY PURPOSE OF COMPANIES AND ANY PURPOSE OF ANY	S COMPATION THAT IT IS			

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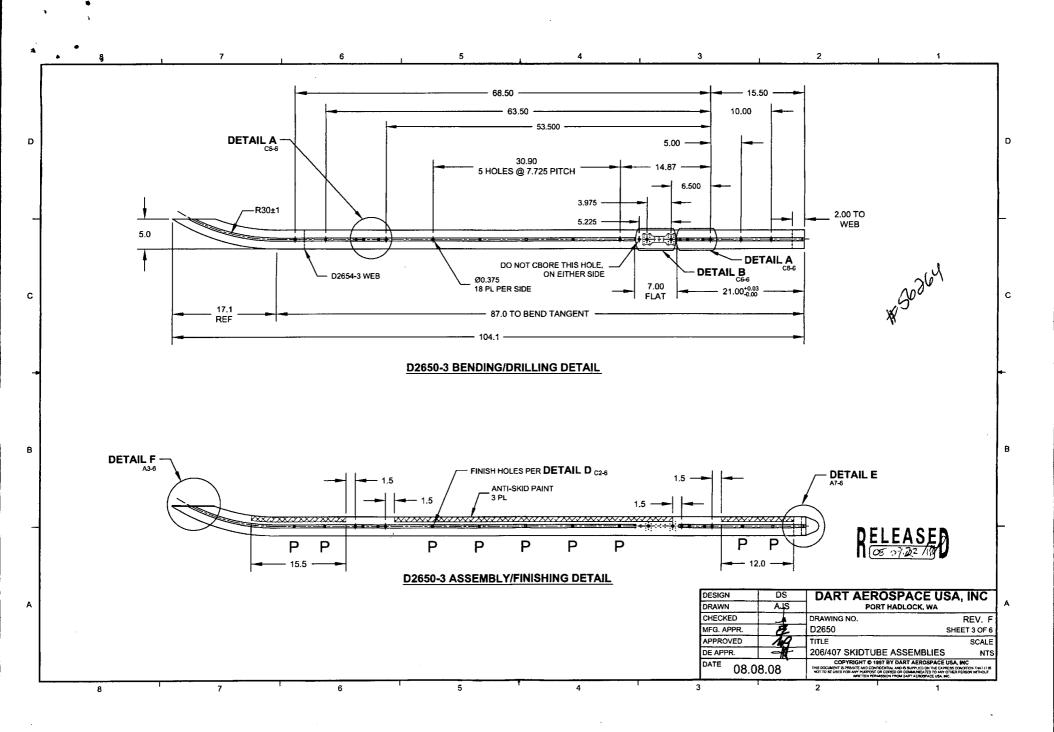
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W/O:			WC	RK ORDER CHANG	GES	H-11-	7.7.0		
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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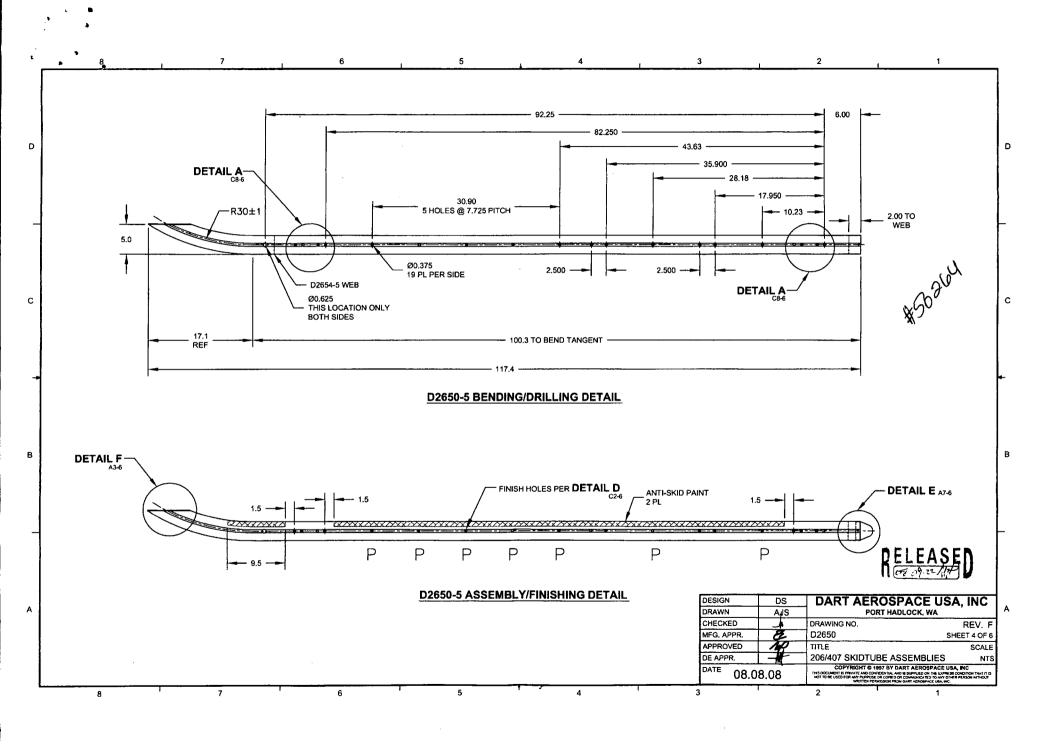
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Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:  Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE   STEP   Description of NC   Corrective Action   Section B   Verification   Approval   A	W/O:			WC	RK ORDER CH	ANGES				***			
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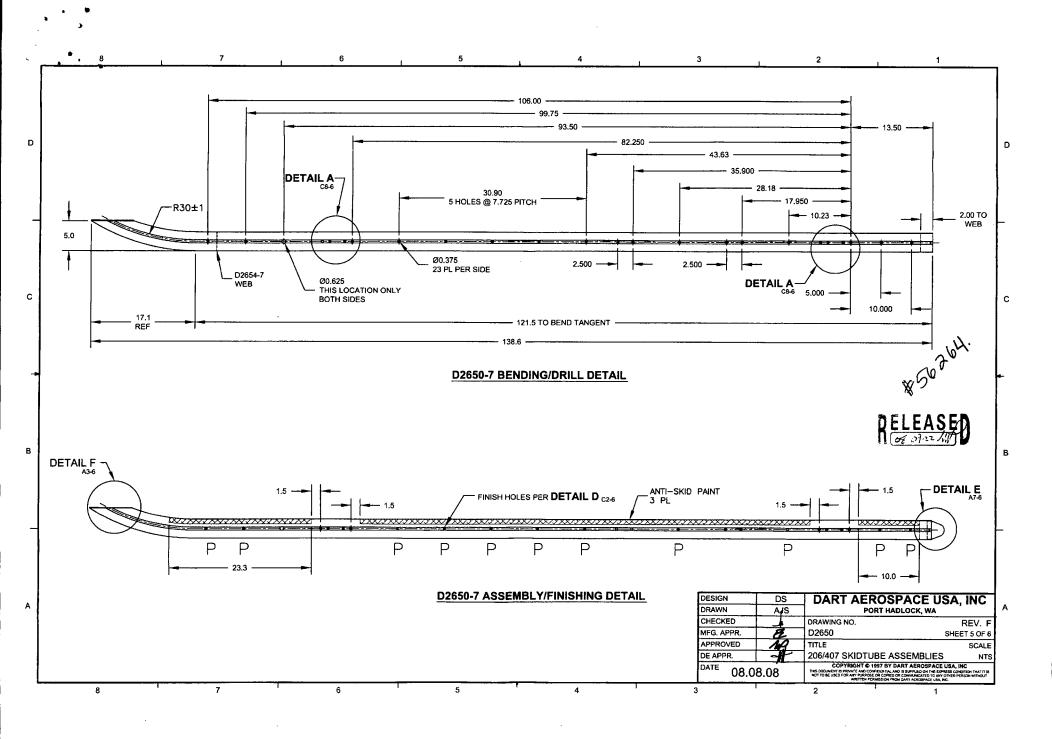
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W/O:			W	ORK ORDER CHANG	GES				
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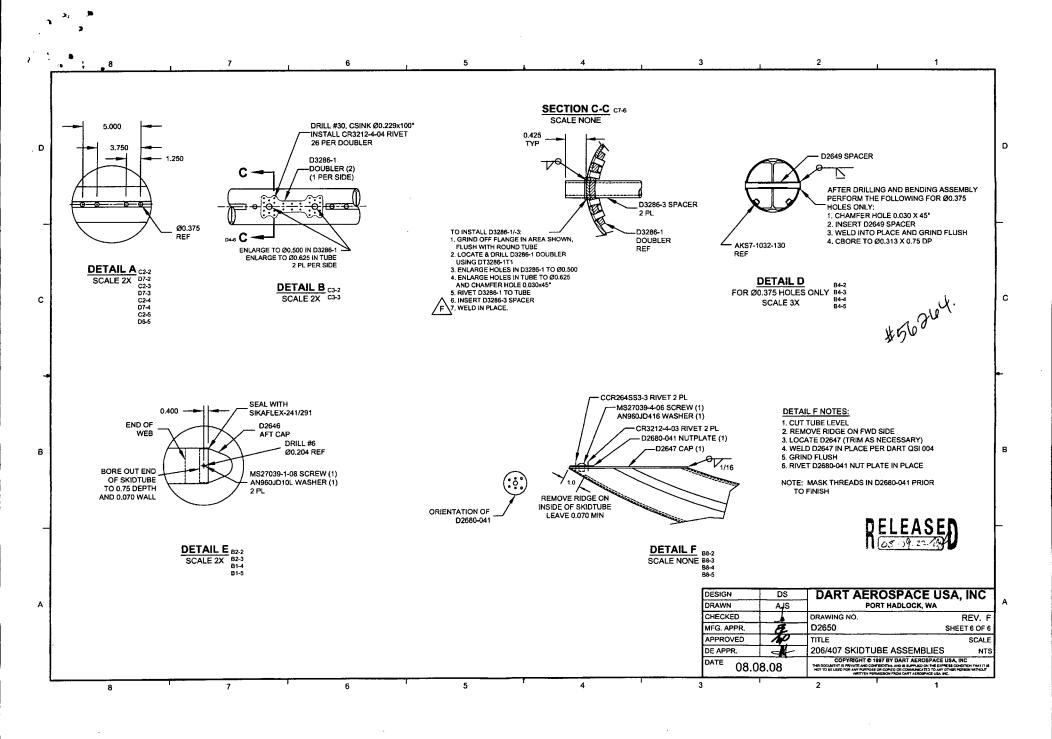
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W/O:			W	ORK ORDER	CHANGES			· · ·		
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Part No		PAR #:								
Resolution:		solution:						Date:		
NCR:			WORK ORE	DER NON-COM	IFORMAN	CE (NCR	)			
DATE	STEP	Description of NC	Initial	Corrective Action  nitial Action Descrip		Section B on Sign &		Verification	Approval	Approval
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Resolution:									
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)	)	·- <u>-</u>		
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign &	Verification verification		Approval	Approval
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	<b>4</b> :	Date:	
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DATE STEP		Describuon of NC		etion B Verification Approv			Approval	i Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
				·					

NO.<u>323</u>

## AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Parcles Fillsoft
Job number: 18 55777
Part number: 0200 - 642 - 441
Description: 200 skid tobe
Welding Process: Tig[/ Mig[]
Base materiel: Aluminian
Current: AC[ DC[ ]

## TEST REQUIREMENTS AND RESULTS

Visual:	$pass[\sqrt{1}]$ fail[ ]
Penetration:	pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks:	pass[ / fail[ ]
Undercut:	pass[/] fail[ ]
Pin holes:	pass[ ] fail[ ]
Overlap (cold lap)	pass[/] fail[ ]
Porosity (surface):	pass[/] fail[]
Coloration:	pass[/] fail[ ]
Qualifier And Sally	Date of Test Coupon 10.02.16
Welder Devoluteliet	Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld